

Work Order ID 83932

83932

Page 1

April-27-12 2:16:58 PM

Item ID: D412-786-013

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Hardpoint Installation

Start Date: 27/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/04/27

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D412-786-013 chg001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MLJ 12/05/09

120509

12/5/09

120509

120509

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

April-27-12 2:16:58 PM

Item ID: D412-786-013 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Hardpoint Installation
 Start Date: 27/04/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/05/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-786-013								
	Location: _____								
	PPP Rev: _____								
140									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

PP 839328

12/05/09

MLJ 12/05/09

MLJ 12/05/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

April-27-12 2:17:01 PM

Page 1

Work Order ID: 83932

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Parent Item: D412-786-013

D412-786-013

Parent Item Name: Fwd Hardpoint Installation

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 12-04-27 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3870-041

D3870-041

Hardpoint, FWD LH

D3870-042

D3870-042

Hardpoint, FWD RH

D3870-5

D3870-5

Mount, Fwd Upper

Manufactured No

Each 0.0000

**

Manufactured No

Each 0.0000

**

Manufactured No

Each 2.0000

**

Location

Loc Qty

Loc Code

Mezz

2

46675

2

Manufactured No

Each 2.0000

**

Location

Loc Qty

Loc Code

Mezz

2

44962

2

Manufactured No

Each 2.0000

**

Location

Loc Qty

Loc Code

Mezz

2

44963

2

D3871-1

D3871-1

Doubler

D3871-2

D3871-2

Doubler

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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April-27-12 2:17:01 PM

Page 2

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Parent Item: D412-786-013

Parent Item Name: Fwd Hardpoint Installation

83932

D412-786-013

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

Each

3,244.000

**

MS21042L3

Nut

Location

Loc Qty

Loc Code

ST300

3244

117441

16

117885

32

118451

5

118927

3

119017

1189

119075

158

121349

841

121444

1000

MS27039-1-10

Purchased

No

Each

62.0000

**

MS27039-1-11

Screw

Location

Loc Qty

Loc Code

Mezz

62

9662

62

Each

236.0000

**

MS27039-1-12

Purchased

No

MS27039-1-12

Screw

Location

Loc Qty

Loc Code

Mezz

236

100993

236

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 3

Work Order ID: 83932

83932

Parent Item: D412-786-013

D412-786-013

Parent Item Name: Fwd Hardpoint Installation

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-14

Purchased

No

Each

186.0000

MS27039-1-14

Screw

**

Location

Loc Qty

Loc Code

GA

169

120177

69

120449

100

ST291

17

112312

17

Each

2,508.0000

**

NAS1149D0332.I

Purchased

No

NAS1149D0332.I

Washer

Location

Loc Qty

Loc Code

ST298

2508

105793

12

110985

4

117087

89

119042

38

119717

541

120644

193

121011

1631

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

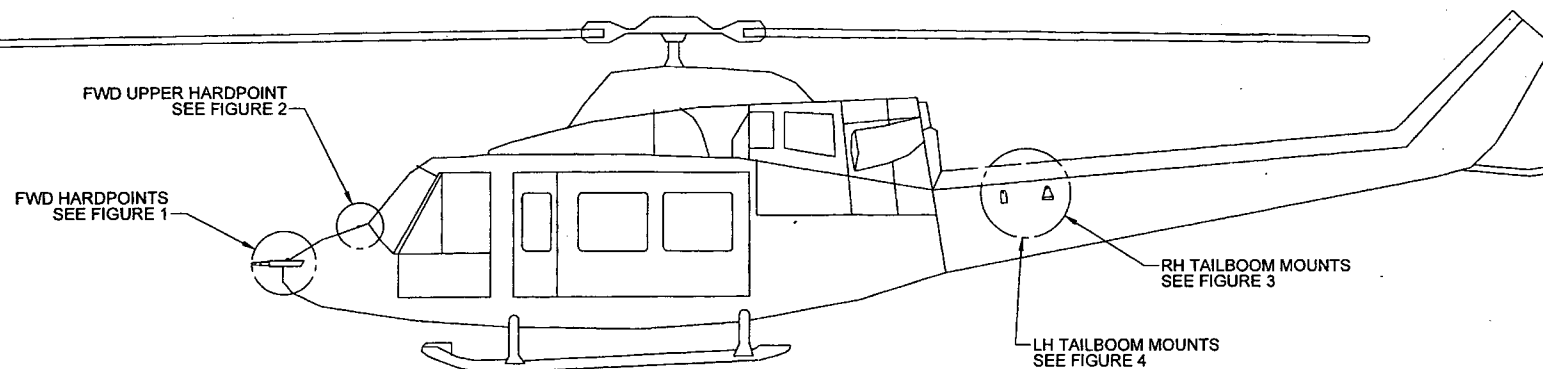
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY



D412-786-011 HARDPOINT KIT

QTY -011	QTY -013	QTY -015	PART NUMBER	DESCRIPTION
X			D412-786-011	HARDPOINT KIT
1	X		D412-786-013	FWD HARDPOINT KIT
1		X	D412-786-015	TAILBOOM MOUNT KIT
		1	D3866-041	TAILBOOM MOUNT
		2	D3866-043	TAILBOOM MOUNT
			D3870-041	FWD LH HARDPOINT
			D3870-042	FWD RH HARDPOINT
			D3870-5	FWD UPPER HARDPOINT
			D3871-1	DOUBLER
			D3871-2	DOUBLER
		12	MS21042L3	NUT
		12	MS27039-1:11	SCREW
			MS27039-1:12	SCREW
			MS27039-1:14	SCREW
		24	NAS1148D0332J	WASHER

INSTALLATION	WEIGHT	LONGITUDINAL		LATERAL	
		ARM	MOMENT	ARM	MOMENT
D412-786-011 HARDPOINT KIT	0.58 LBS 0.22 KG	164.67 IN 4.18 M	95.51 IN 0.92 KG-M	-1.25 IN -0.03 M	-0.73 IN-LB -0.007 KG-M
D412-786-013 FWD HARDPOINT KIT	0.22 LBS 0.08 KG	-13.55 IN -0.34 M	-2.98 IN-LB 0.03 KG-M	2.36 IN 0.06 M	0.52 IN-LB 0.005 KG-M
D412-786-015 TAILBOOM MOUNT KIT	0.36 LBS 0.13 KG	273.58 IN 6.95 M	98.49 IN-LB 0.90 KG-M	-3.47 IN -0.09 M	-1.25 IN-LB -0.01 KG-M

RELEASED

NOTES:

- 1) D412-786-011 HARDPOINT KIT REQUIRED ON 412/412EP AIRCRAFT UTILIZING D412-695-011 BLADE FOLDING KIT WHERE WIRE STRIKE COMPATABILITY IS REQUIRED
- 2) TOUCH UP DRILLED HOLES WITH ALODINE PER THE AIRCRAFT MAINTENANCE MANUAL
- 3) TORQUE FASTENERS AS FOLLOWS: 10-32: 20-25 IN-LBS
- 4) PRIME AND PAINT HARDPOINTS TO MATCH AIRCRAFT PAINT SCHEME PER AIRCRAFT MAINTENANCE MANUAL

A NEW ISSUE		BY	09.01.14
REV	DESCRIPTION	DATE	
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.	N/A		
APPROVED			
DE APPR.			
DATE	09.01.14		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D412-786-1	REV. A SHEET 1 OF 5
TITLE HARDPOINT KIT INSTALL	SCALE NTS
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